

Date: Thursday, 4/12/2007 8:52:30 AM
 User: Kim Johnston

Process Sheet

Split SB 07/05/11

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LH ACTUATOR ASSEMBLY
 Job Number : 31745-2
 Estimate Number : 12761
 P.O. Number : N/A Part Number : 41232 200 001 001
 This Issue : 4/12/2007 S.O. No. : N/A Drawing Number : 41232-200-001 REV IR
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : IR
 Previous Run : 31450 Material : N/A
 Due Date : 5/10/2007 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : 07.04.12
 Comment : Est Rev. A New Issue 07-02-28 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MS208224 elbow



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

elbow

Batch: M103688

SB 07/05/11 ③

2.0 124K002 4CR 0545 Hose ass'y-Step Actuator



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hose ass'y-Step Actuator

BATCH:

720 of packing kit

3.0 AN8424D Elbow



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Elbow

Batch: M104156

SB 07/05/11 ③

4.0 41232 200 007 001 Brass Cylinder Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Brass Cylinder Assembly

Batch: B30942

SB 07/05/11 ③

5.0 MS1699623 cap screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

cap screw

Batch: M103934

SB 07/05/11 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/11	14	Split w/o	S/S	07/05/11	3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:52:30 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 31745

Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN3154R

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M 17566

SB 07/05/15 ③

7.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M 102929

SB 07/05/15 ③

8.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M 100743

SB 07/05/15 ③

9.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M 104215

X

10.0

AN322A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M 3413

SB 07/05/15 ③

11.0

41232 200 005 003

Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer (Step Actuator)

Batch: B 31022

SB 07/05/15 ③

12.0

41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pivot arm

Batch: B 31021

(B 31775 ③ X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 7 Date: 09/05/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:52:30 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 31745

Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

latch

Batch: B 31778

14.0

41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

tube

Batch: B 31019 ①

B 31776 ②

15.0

41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Decal

Batch: M 31023

SB 07/05/15 ③

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

SB 07/05/15 ③

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005.16 ③

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/17 ③

19.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

07/05/17 ③

Job Completion



U 07/05/17

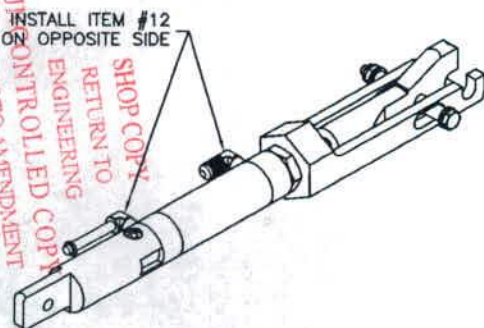
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/15		Spring S1455 Batch M104079 Part E Regan Batch M104251 on spring	SB	07/05/15	3	 07.05.17	 07.05.17

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



INSTALL ITEM #12
ON OPPOSITE SIDE

SHOP COPY

RETURN TO





ENGINEERING

CONTROLLED CO
AMENDMENT

WITHOUT NOTICE

WORK ORDER
21745

NO 31/42

- | | |
|---|-----------------------|
|  | TORQUE 80-100 IN.-LB. |
|  | TORQUE 20-25 IN.-LB. |
|  | TORQUE 50-75 IN.-LB. |
|  | TORQUE 50-75 IN.-LB. |

NOTES:

			1	1	15	3/4x20 BRASS	CYLINDER NUT					
			1	1	14	MS20822-4	ELBOW					
			1	1	13	AN842-4D	ELBOW					
			1	1	12	41232-200-007-001	CYLINDER					
			1	1	11	71459	SPRING					
			1	1	10	MS16996-23	CAP SCREW					
			1	1	9	AN315-4R	NUT					
			2	2	8	AN960JD416	WASHER					
			2	2	7	AN960JD10	WASHER					
			1	1	6	MS21042-L3	NUT					
			1	1	5	AN3-22A	BOLT					
			2	2	4	41232-200-005-003	SPACER					
			1	1	3	41232-200-002-005	PIVOT ARM					
			1	1	2	41232-200-002-003	LATCH					
			1	1	1	41232-200-002-001	TUBE					
						-002	R/H ACTUATOR ASSY					
						-001	L/H ACTUATOR ASSY					
			-002	-001	FIG NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE	

PROPRIETARY
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ERA ACTION, INC.
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NOT APPLY TO
VENDOR PARTS.

002
001
DATE-1 INC.

41

41232-000-001

NEXT ASSEMBLY

UNLESS
OTHERWISE
SPECIFIED
X \pm .1
XX \pm .03
XXX \pm .010
ANGLES
 \pm 1/2°

DRAFTSMAN
CHECK
STRESS
PROD. ENGR.
HEAT TREAT
FINISH

D. NELSON	5/20/02
D. MURPHY	5/20/02

Era Ark

TITLE			
STEP ACTUATOR ASSY			
DWG. SIZE	C	SCALE	NONE
DWG. NO.		REV.	
41232-200-001		1F	

